

Work Order ID 52391

Page 1

Tuesday, September 22, 2009 11:17:24 AM

Item ID: D2565-209

Accept



Setup Start



Revision ID: E

Stop



Item Name: Strut

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *PL WIF* Date: 09/22 Tooling: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2565	Rev E

100 0.00

*Sy 09/10/09**5 20*

NC BRAKE

Brake NC

Memo

Brake NC

Punch as per Dwg D2565 using DT 8313

110



Small Fab

Small Fab

Memo

Small Fab

Deburr

120



QC5- Inspect part completeness to step on W/O

QC

Quality Control

Memo

0.00

0.00

*27 S 02/10/13**(5x)**(X5)**f*

Work Order ID 52391

Page 2

Tuesday, September 22, 2009 11:17:24 AM

Item ID: D2565-209

Accept



Setup Start



Revision ID: E

Stop



Item Name: Strut

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Powdercoat

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

11112260

0.00

=7

H 09/09/14

(X5)

P

Powder Coating

Memo

0.00

START TIME: 7:00AM OVEN TEMPERATURE:
FINISH TIME: 4:00PM

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

BL 09-10-14

(5)

0.00

Memo

150



Packaging

Packaging

Identify as per dwg & Stock Location: 203

0.00

Memo

0.00

PC 9/10/15 (5)

Work Order ID 52391

Page 3

Tuesday, September 22, 2009 11:17:24 AM

Item ID: D2565-209

Accept



Setup Start



Revision ID: E

Stop



Item Name: Strut

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/10/15 JJ

MF
09-10-15

Picklist Print

Page 1
1

Tuesday, September 22, 2009 11:17:23 AM

Work Order ID: 52391



Parent Item: D2565-209RevE



Parent Item Name: Strut

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049 		Purchased		No		100	f	286.3500	5.4034 			

304 RD Tube .750 x .049W

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	286.35	
107518	2.77	
108498	0	
109314	8.5	
110113	0.73	
110271	0.03	
111096	9	
111457	11.43	
112652	253.89	

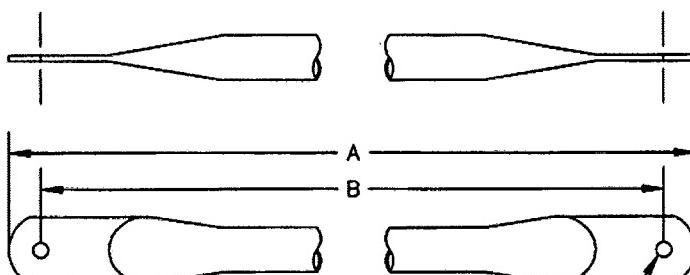
7 88 09/09/09 5

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2565	SHEET 1 OF 1
DATE	TITLE		SCALE
04.05.05	STRUT		1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED

04.05.05



DIA 0.257 TO BE PUNCHED
 "C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 32381

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
 (REF DART SPEC. M304TR0.750W0.049)
 ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.